



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3049-1

Job Sheet 204816



Part No: D3049-1

Job Qty: 8 pcs

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/20/19

Job Tracking No:

Due Date: 2/10/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	8 pcs	2/10/20		0.17	2.39	Waterjet - Flow	DAS	20/01/19
120	HAAS 4 Axis - B4B	8 pcs	2/10/20		1.00	38.65	HAAS - 1 - B4B	52	20/01/19
							HAAS - 2 - B4B	9-89	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 2	8 pcs	2/10/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	DAS	
							QC 2 - 52	52	20/01/19
							QC 2 - 57	9-89	
							QC 2 - 62		
							QC 2 - 63		

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
140	QC 8	8 pcs	2/10/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
170	Packaging 3-1 - Stock - B4B	8 pcs ✓	2/10/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B ✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B

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				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
				QC 21 - SA - 21 ✓ DAS	ST444
				QC 21 - SA - 70 21	
				QC 21 - SA - 53 2-08	JAN 21 2020

Part Op **110** - CUT BLANK AS PER FILE D3049-1_BLANK
 Descriptions: **120** - (HAAS CNC Vertical Machine) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1
130 - (QC2- Inspect parts off machine FAI/FAIB)
140 - (QC8- Inspect parts - second check)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	27,2000 sf (3,4 ea)	110-Waterjet - Flow - 1	S235828

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	MUHMWB10	27	669	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	0.26	Diameter
2	Bearpaw	0.930Inches ± 0.030	0.960 0.900	0.930	
3	Bearpaw	0.400Inches + 0.030 - 0.000	0.430 0.400	0.405	
4	Bearpaw	2.000Inches ± 0.030	2.030 1.970	2.000	
5	Bearpaw	10.310Inches ± 0.010	10.320 10.300	10.310	
6	Bearpaw	2.870Inches ± 0.030	2.900 2.840	2.870	
7	Bearpaw	8.000Inches ± 0.030	8.030 7.970	8.000	
8	Bearpaw	0.380Inches ± 0.030	0.410 0.350	0.380	
9	Bearpaw	11.500Inches ± 0.030	11.530 11.470	11.500	
10	Bearpaw	0.070Inches ± 0.030	0.100 0.040	0.05	
11	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	45°	Angle
12	Bearpaw	0.440Inches + 0.030 - 0.000	0.470 0.440	0.460	
13	Bearpaw	0.250Inches ± 0.030	0.280 0.220	0.250	Radius
14	Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940	0.960	
15	Bearpaw	0.690Inches ± 0.030	0.720 0.660	0.705	
16	Bearpaw	0.200Inches ± 0.030	0.230 0.170	0.200	
17	Bearpaw	0.250Inches ± 0.030	0.280 0.220	0.250	Radius
18	Bearpaw	0.250Inches ± 0.030	0.280 0.220	0.250	
19	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	45°	Angle

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S245159



Part: D3049-1

Job No: 204816

Serial No/Batch: S245159

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/07/20